

Work Order ID 68485

Thursday, April 14, 2011 10:03:01 AM

Page 1

Item ID: D3315-3

Accept

Revision ID:

Item Name: Wearplate

Start Date: 4/14/2011 Start Qty: 4.00

Required Date: 4/21/2011 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date: 4/14/11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3315

Rev B

100

0.00



Waterjet

FLOW CNC Waterjet

1010, 063

FLOW WATER JET

Memo

1-Cut as per Dwg D3315 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

0.00

B11-5-3

B11-4-18

(4)

110

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

-0.00

B11-5-3

B11-4-18

120

0.00



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

81010103

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68485

Thursday, April 14, 2011 10:03:01 AM



Page 2

Item ID: D3315-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 4/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	NC BRAKE	0.00							
Brake NC	Memo	0.00		88 11/05/03		(4)			
Brake NC	Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: <u>B</u>								
140 	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00		88 11/05/03		(4)			
Quality Control									
150 	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	Weld hard surface using D3315-3T3 as per QSI 004 and Dwg D3315 Rev: <u>B</u>								
	<input checked="" type="checkbox"/> Qty Part Number Description Batch <input type="checkbox"/> A/R								
	N/A 7560 Hardcoat Rod <u>M117139</u>								

EL 11-6-00 (64)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 68485

Thursday, April 14, 2011 10:03:02 AM



Page 3

Item ID: D3315-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 4/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8 w/06/21

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 w/06/21

(+4)

180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3:30

4:00

3200F

4X Ø M-14/06/21

M115128

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 68485

Thursday, April 14, 2011 10:03:02 AM



Page 4

Item ID: D3315-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 4/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

70 BL 11-06-22

200



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify on inside surface using a permanent fine point marker with the following: ☐TCCA-PDA, Dart Aerospace Ltd. ☐P/N: D3315-3, B/N: BXXXXX ☐For Product Eligibility see PDA04-17 ☐and Stock ☐Location: ST 496

11/6/22 (4)

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/6/22

11-06-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 14, 2011 10:03:08 AM

Page 1

Work Order ID: 68485

Parent Item: D3315-3

Parent Item Name: Wearplate



Start Date: 4/14/2011

Required Date: 4/21/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: A ☐ 05.05.12 ☐ New issue ☐ KJ/JLM ☐
 IPP Rev:B As per Rev B 06-03-24 JLM
 IPP Rev:C Now on Waterjet 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M1010S16GA

Purchased

No

100

sf

38.0000

2.296

9.667368



1010/1025 sheet 16GA



Location

Loc Qty

Loc Code

MAT019

38

116791

38

117 500

B11-4-18
B11-5-3

117 500
~~116 791~~

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	68985
Description: Wearplate		Part Number:	D3315-3
Inspection Dwg: D3315 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
62.75	+/-0.030	62.75	✓		T B01	
58.094	+/-0.010	58.094	✓		T	
51.368	+/-0.010	51.368	✓		T	
44.531	+/-0.010	44.531	✓		T	
37.719	+/-0.010	37.714	✓		T	
30.375	+/-0.010	30.375	✓		T	
24.188	+/-0.010	24.188	✓		T	
18.875	+/-0.010	18.875	✓		T	
17.375	+/-0.010	17.375	✓		T	
10.594	+/-0.010	10.594	✓		T	
5.375	+/-0.010	5.375	✓		V B02	
0.875	+/-0.010	.881	✓		V	
1.62	+/-0.030	1.623	✓		V	
5.214	+/-0.010	5.210	✓		V	
4.402	+/-0.010	4.409	✓		V	
3.550	+/-0.010	3.555	✓		V	
Ø0.300	+0.006/-0.001	.302	✓		V	
Ø0.266 x 0.450	+/-0.010	Ø0.266 x 0.456	✓		V	

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	11-5-3	Date:	4/05/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.22	New Issue	KJ/EC/DD	DS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

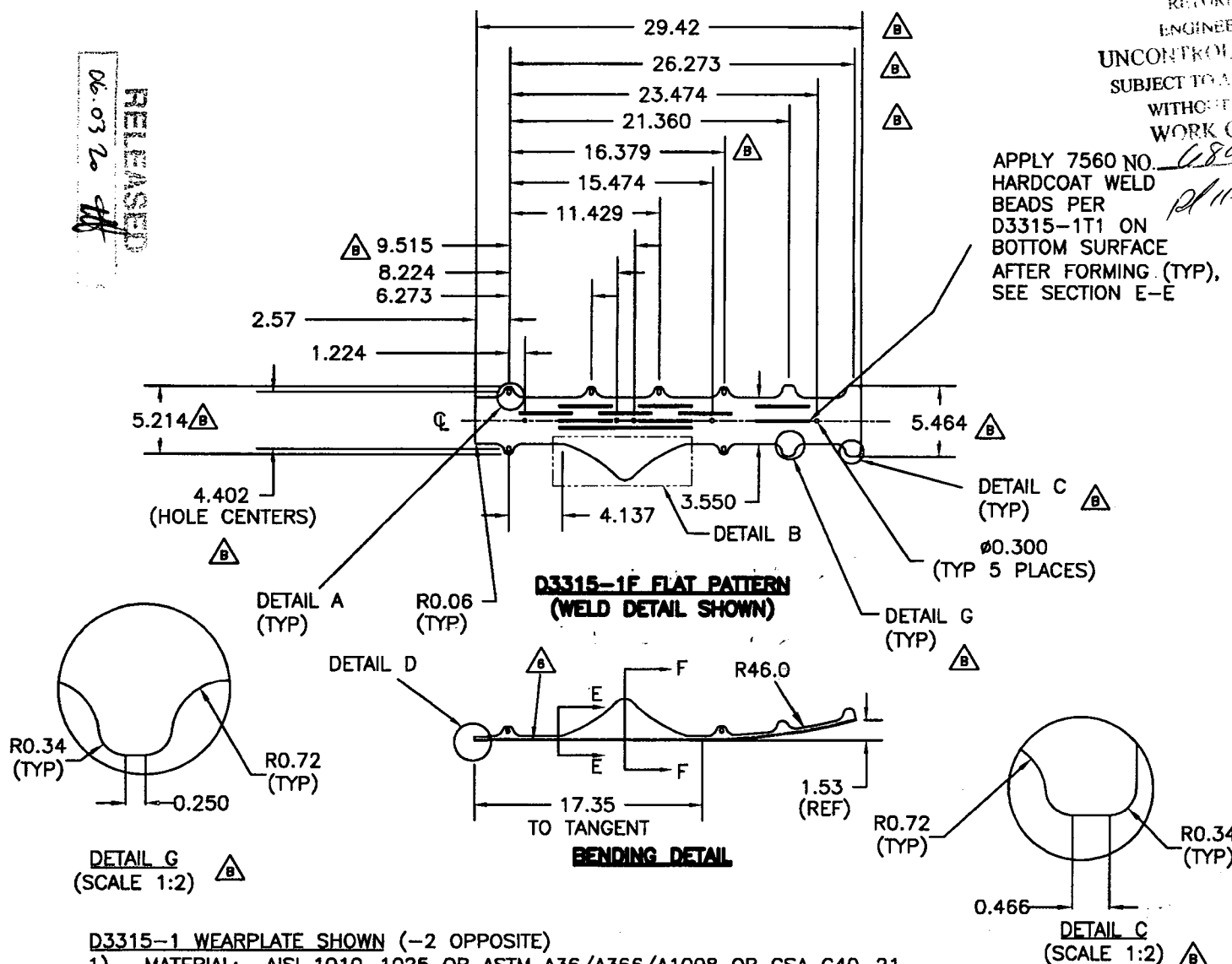
NOTE: Date & initial all entries

DART

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

APPLY 7560 NO. 68485
HARDCOAT WELD
BEADS PER
D3315-1T1 ON
BOTTOM SURFACE
AFTER FORMING (TYP),
SEE SECTION E-E

DESIGN	DRAWN BY	DART AEROSPACE LTD
04	04	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3315
DATE	TITLE	REV. B
06.01.31	WEARPLATE	SHEET 1 OF 4
A	NEW ISSUE	SCALE
04.09.10		1:12
B	UPDATE DIMENSIONS	
06.01.31		



D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
 - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
 - 3) WELD PER DART QSI 004
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
- *TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

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RELEASED
06.03.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

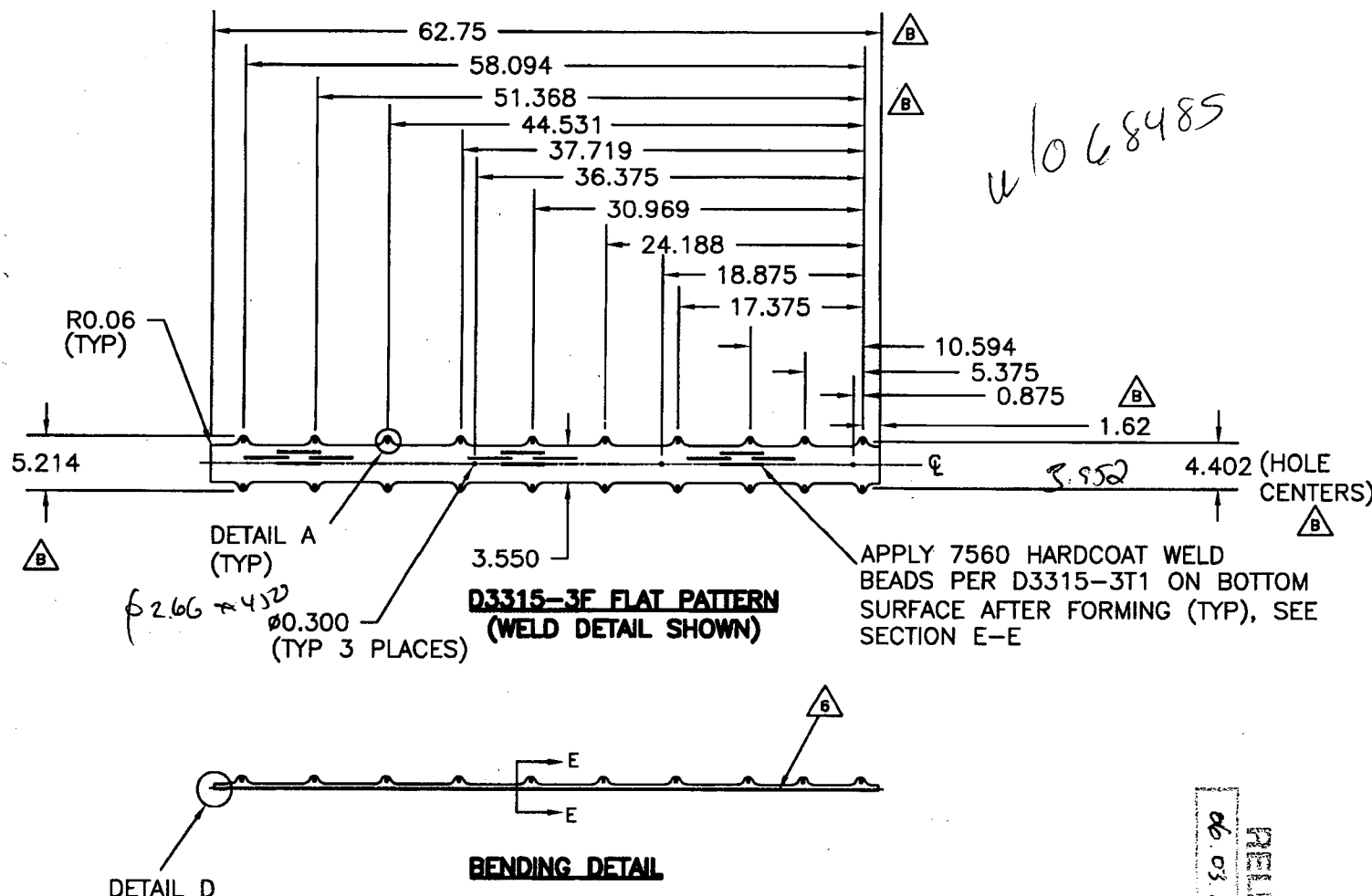
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3315
DATE	06.01.31	TITLE	WEARPLATE	REV. B
		SCALE	1:16	SHEET 2 OF 4



D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

RELEASED
06.03.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

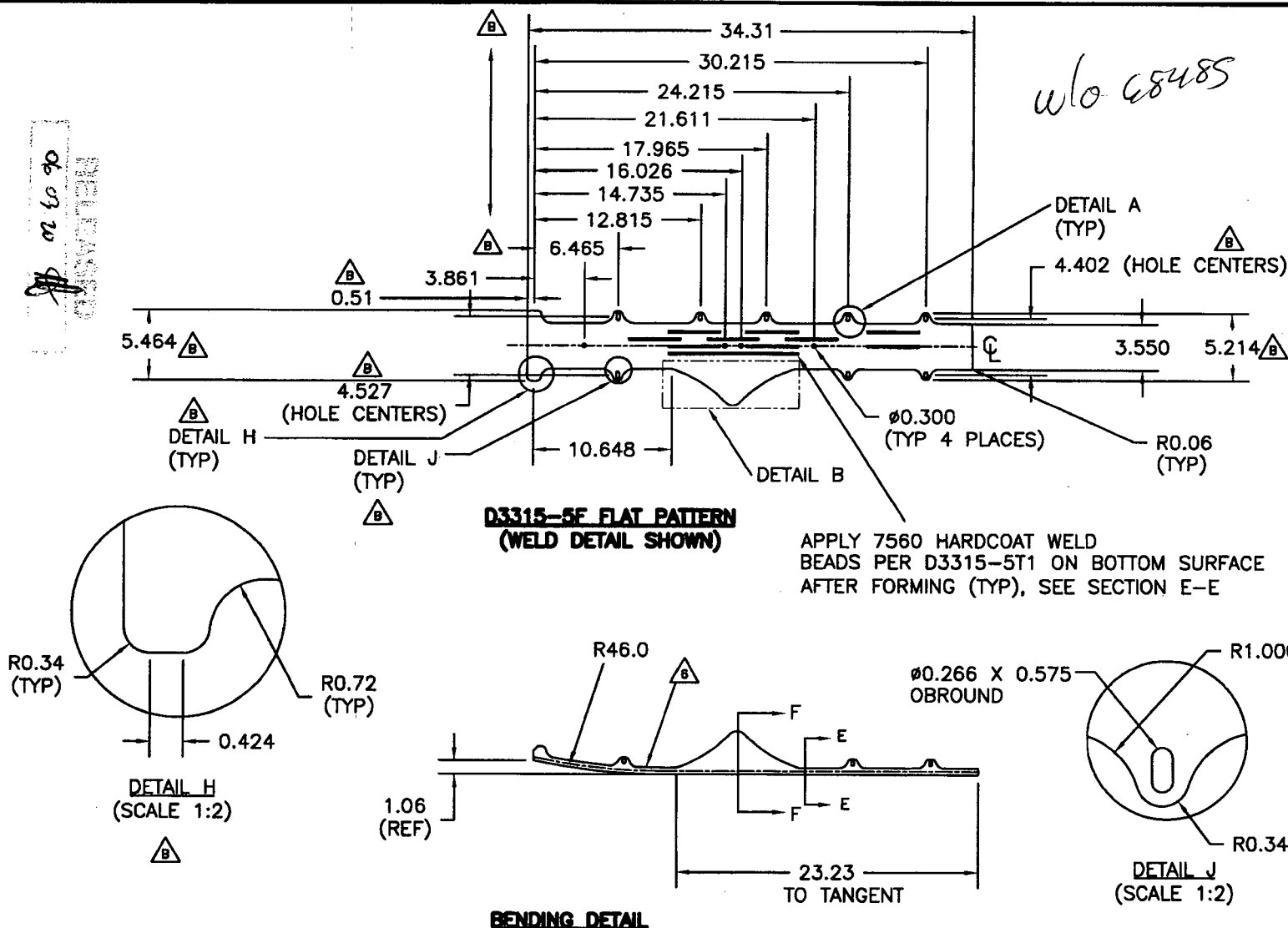
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
84	84	DRAWING NO.	REV. B
CHECKED	APPROVED	D3315	SHEET 3 OF 4
DATE	TITLE	WEARPLATE	SCALE
06.01.31			1:12



D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

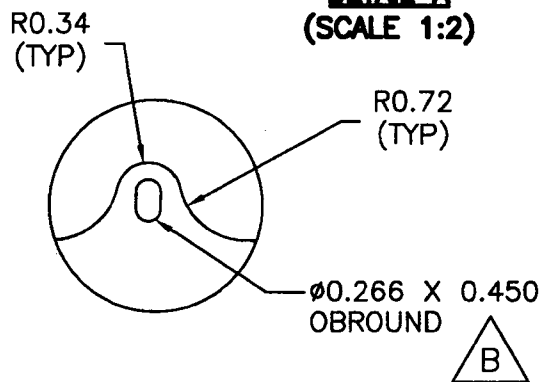
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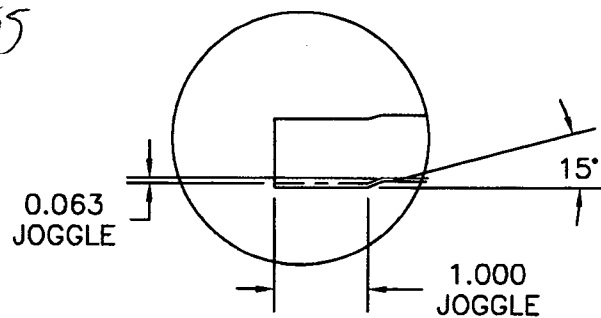


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
04	04	DRAWING NO.	REV. B
CHECKED	APPROVED	D3315	SHEET 4 OF 4
DATE	TITLE	WEARPLATE	SCALE
06.01.31			NTS

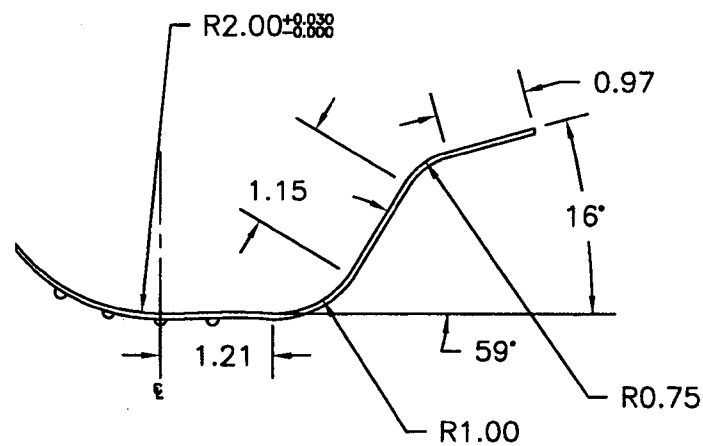
DETAIL A
(SCALE 1:2)



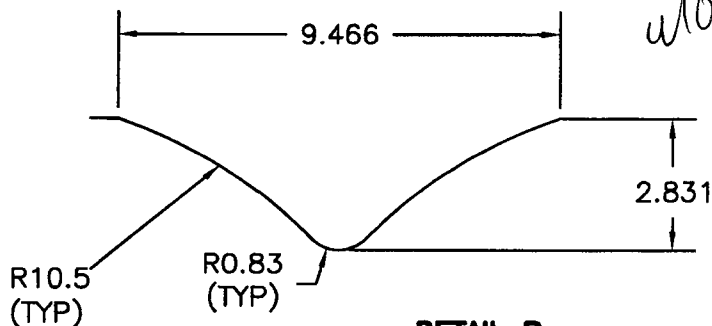
DETAIL D
(SCALE 1:2)



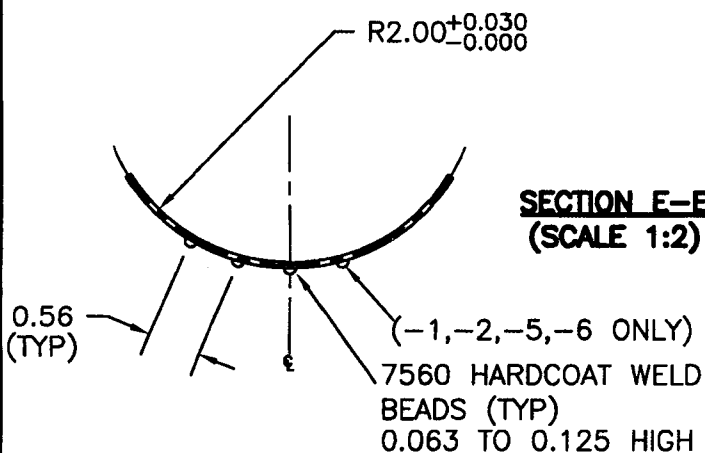
SECTION F-F
(SCALE 1:2)



DETAIL B
(SCALE 1:4)



SECTION E-E
(SCALE 1:2)



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